Date:

Friday, 09/05/2008 1:45:24 PM

User:

Julie Lecoca

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 39153 : 10173

P.O. Number

Estimate Number

This Issue

Prsht Rev.

First Issue

Previous Run

: 09/05/2008

: NC

: // : 37605

S.O. No. :

: MACHINED PARTS Type

Part Number

Drawing Name

: D2537 : D2537 REV A1

Drawing Number

Project Number : N/A

: A1

Material **Due Date**

Drawing Revision

: 23/05/2008

: BUSHING

Qty:

Each

Written By **Checked & Approved By**

Comment

Material change on Step 2 KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M304R500

0.500" 304 SS roundbar



Comment: Qty.:

0.1203 f(s)/Unit Total: 6.0165 f(s) M106353 x 23

Material: AISI 304/316 Round Bar Ø0.500"(M304R.500)

Batch: MK95261 X115 PCS

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA273

2-Deburr and Tumble

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPEC PARTS AS THEY COME OFF MACHINE

SECOND CHECK



4.0

QC8





Comment: SECOND CHECK

PACKAGING 1 5.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:_

W/O:		WORK ORDER CHA	NGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	 A:	Date:	

QA: N/C Closed: ____ Date: __

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Approval	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector			
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				(b							
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Date: User: Friday, 09/05/2008 1:45:24 PM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 39153

Part Number: D2537

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/20 H

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					The state of the s		

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector		
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						,				
						949				

DART AEROSPACE LTD	Work Order: 39153
Description: Bushing	Part Number: D2537
Inspection Dwg: D2537 Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Art	icle	Protot	уре
 		4.0			

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1,250"				
0.316	+0.005/-0.000	Ø,320°				
Ø0.438	+/-0.010	D, 438"				
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				,		
				340		WH.
	(4.)					
		4				
				2		
		"				
<u> </u>						
		-				

Measured by:	J.F.	Audited by:	Prototype Approval:	N/A
Date:	08/05/13	Date: 05/05/3	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue	KJ/RF	
В	05.02.17	Added Ø0.438	KJ/JLM LA	
С	07.10.31	Tolerance revised on Ø0.438	KJ/EC/DD	<i>X</i>

W/O:		WORK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ/	\ :	Date:	1

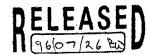
QA: N/C Closed: ____ Date: __

NCR:	9-	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC'	Corrective Action Section B			Verification	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		

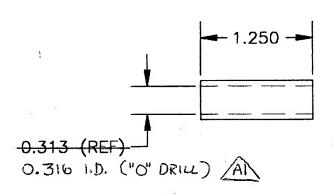




DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROS	
M. M.		DRAWING NO. D2537	REV. A SHEET 1 OF 1
DATE		TILE	SCALE
96:05:15	1	BUSHING	1:1
AL 02 0	932/10/1	0.74 MAS 077	







SHOP COPY

RETURN TO

ENGINEERING

MATERIAL: 304/316 SS 7/16 OD 0.063 WALL UNCONTROLLED COPY OR COGS WALL

KE 99.09.0 SUBJECT TO AMENDME

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		[4]		*						
<u>. </u>	P			Ē						

Part No:	PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:
			QA: N	1/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector				
DATE	STEP	Section A	Initial Action Description: Chief Eng Chief Eng					Sign & Date			
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